



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3278-1
Job Sheet 169565



Part No: D3278-1

Job Qty: 50 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/21/17

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 rev.c dwg EC verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		12/20/17	0.00	0.00	Start Up Machining-2		
100	Bandsaw	50 pcs		12/20/17	0.00	1.44	Bandsaw1		
110	CNC Vertical Machining	50 pcs		12/20/17	0.06	15.68	HAAS 5 Axis		
130	QC	50 pcs		12/20/17	0.00	0.00	QC8 Machining-2		
140	HandFinish	50 pcs		12/20/17	0.00	0.48	HandFinish1		
150	Powdercoat	50 pcs		12/21/17	0.00	0.37	Powdercoat1		
155	Packaging	50 pcs		12/21/17	0.00	0.00	Packaging2		
160	QC	50 pcs		12/21/17	0.00	0.00	QC3		
170	Packaging	50 pcs		12/21/17	0.00	0.00	Packaging3-1		
180	QC21-SA	50 Ea		12/21/17	0.00	0.00	QC21		

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long

Descriptions: 110 - 1- Machine as per Folio FA405 and Dwg D3278-2-Deburr and Tumble Identify as D3278-1

150 - START TIME: 1:05 O.T. 320° FINISH 1:35

170 - LOCATION : GA

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X02.000	12	27	0	0

D3278-1P

Batch # 5008416 x 50 PCS 10.625'

5025345

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359inches ± 0.005	0.364 0.354		
3	Support	0.609inches ± 0.010	0.619 0.599		
4	Support	0.250inches ± 0.010	0.260 0.240		
5	Support	1.480inches ± 0.005	1.485 1.475		
6	Support	0.125inches ± 0.010	0.135 0.115		
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115		
8	Support	2.439inches ± 0.010	2.449 2.429		
9	Support	1.980inches ± 0.010	1.990 1.970		
10	Support	0.130inches ± 0.030	0.160 0.100		
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257		
12	Support	0.375inches ± 0.010	0.385 0.365		
13	Support	0.875inches ± 0.010	0.885 0.865		
14	Support	0.500inches ± 0.010	0.510 0.490		
15	Support	0.400inches ± 0.010	0.410 0.390		
16	Support	1.000inches ± 0.030	1.030 0.970		
17	Support	1.720inches ± 0.010	1.730 1.710		
18	Support	0.125inches ± 0.010	0.135 0.115		
19	Support	0.125inches ± 0.010	0.135 0.115		

DART
AEROSPACE
S025346



Support

PART NO: D3278 – 1
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/20/17
Job No: 169565

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

12/13/17 2:34 PM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038710

Supplier: MEM001-VC
Metex Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K6A 1K7 Canada
Phone: 613 678 3957
Fax: 613 678 3956

PO No: PO038710
PO Date: 12/22/17
Due Date: 1/12/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lacelle, Linda
Phone: llacelle@dartaero.com

Attention: Walz, Shigi

Via: Ground

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613 632-5200

Payment Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3278-1P			Support	Firmed	1/12/18	50 Ea	0 Ea	50 Ea	\$23.20/Ea	\$1,160.00
2	D3278-2P			Support	Firmed	1/12/18	50 Ea	0 Ea	50 Ea	\$23.20/Ea	\$1,160.00
3	D3886-1P			Lug	Firmed	1/12/18	37 Ea	0 Ea	37 Ea	\$29.00/Ea	\$1,073.00
4	D3414-3P			Lug	Firmed	1/12/18	60 Ea	0 Ea	60 Ea	\$29.00/Ea	\$1,740.00
5	D3404-1P			Ground Handling Wheel Lug	Firmed	1/12/18	60 Ea	0 Ea	60 Ea	\$29.90/Ea	\$1,794.00
Grand Total:										\$6,927.00	

Order Notes

Terms & Condition of Purchase (Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/22/17 3:35 PM dart.lacelle.linda



20 Terry Fox Drive
 Vankleek Hill, Ontario K0B 1R0 , Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 21944
Date: Jan 26, 2018
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO038710	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jan 26, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D3278-1 Support, as per drawing D3278 Rev C		Each	50	50	18/1/26
D3278-2 Support, as per drawing D3278-2 Rev C		Each	50	50	
D3886-1 Lug, as per drawing D3886 Rev B		Each	37		
D3414-3 Lug Assembly in SS, material supplied precut		Each	60		
D3404-1 GHW/Lug, as per drawing D3404-1 Rev C		Each	60		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					
Received by _____		Thank you for your order!			



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
50	D3278-1	Lug	164565	Unpainted	38710
50	D3278-2	Lug	169567	Unpainted	38710

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, January 26, 2018